

# Work Order ID 53023

October 22, 2009 9:44:59 AM



Page 1

Item ID: D3531-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket

Start Date: 21/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*PL*

Date: 09-10-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3531

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3531 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Deburr if necessary

0061  
040

13 9-11-5

11

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

13 9-11-5

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) Solutoc

13

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Page 2

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Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE  Memo Bend as per Dwg D3531	0.00  0.00	86 09/11/16			11	0		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	2) 80 09/11/18			(80)	0		
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	=> 81 09/11/19			11	0		

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Page 3

Item ID: D3531-1

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Stop



Item Name: Bracket

Start Date: 21/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

BR 09-11-19

(11)



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 1H

0.00



Packaging

Memo

0.00

Packaging

09/11/23 (11)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/24

09-11-23

(11)

# Picklist Print

Page 1

October 22, 2009 9:45:04 AM

Work Order ID: 53023

Parent Item: D3531-1RevA

Parent Item Name: Bracket


Comments:

Start Date: 21/10/2009

Required Date: 30/10/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	90.3986	2.3893	4.79		
												
6061-T6 .040 Sheet												

189-11-5

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	90.3986	
100742	3.3	
102723	5.93	
105842	12	
106747	5.7516	
107461	11.7841	
109396	22.28	
111224	27.8529	
19380	1.5	

111224

11

DART AEROSPACE LTD		Work Order:	53023
Description: Bracket		Part Number:	D3531-1
Inspection Dwg: D3531 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

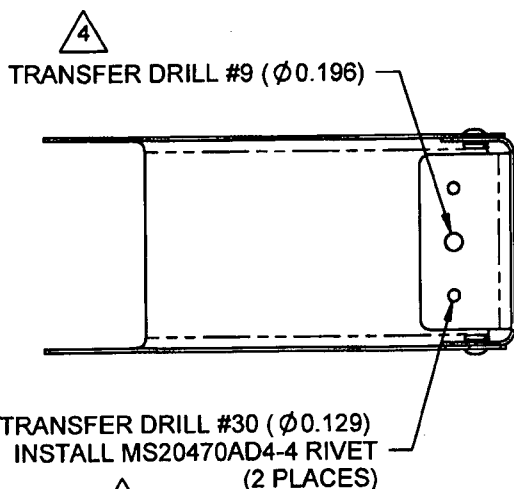
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005/-0.001	-199	✗			
Ø0.129	+0.005/-0.001	.130	✗			
0.33	+/-0.030	.334	✗			
2.840	+/-0.010	2.840	✗			
1.70	+/-0.030	1.702	✗			
1.45	+/-0.030	1.454	✗			
0.38	+/-0.030	.375	✗			
0.19	+/-0.030	.191	✗			
5.88	+/-0.030	5.883	✗			
12.66	+/-0.030	12.66	✗			
0.600	+/-0.010	-.600	✗			
1.77	+/-0.030	1.77	✓			
1.24	+/-0.030	1.242	✗			
1.16	+/-0.030	1.16	✗			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-11-5	Date: 07/10/06	Date:	N/A

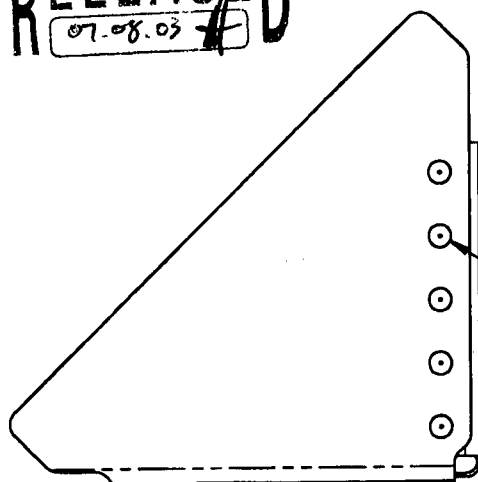
Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	AS



DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>HA</b>	DRAWING NO. <b>D3531</b>	REV. A SHEET 1 OF 3
DATE <b>07.06.19</b>	TITLE <b>BRACKET ASSEMBLY</b>		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

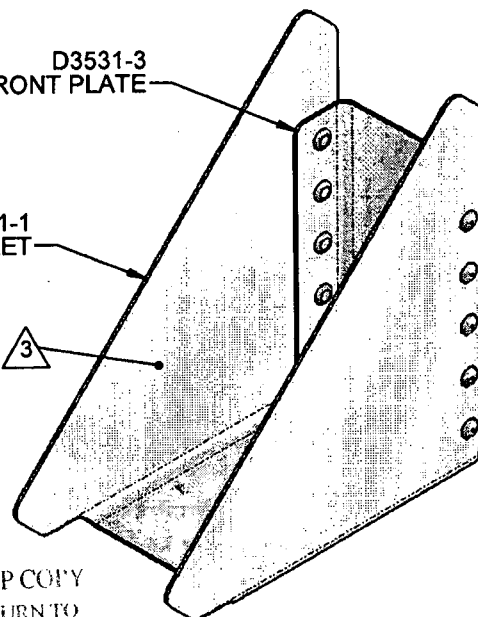


**RELEASED**  
07.08.03



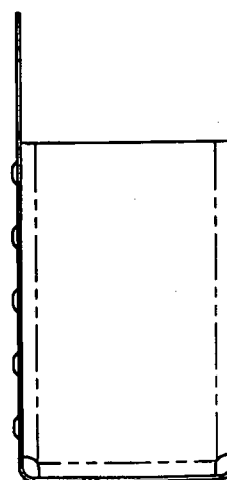
D3531-3  
BRACKET FRONT PLATE

D3531-1  
BRACKET



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WORK ORDER  
NO. 53023  
09-10-22

MS20470AD4-4  
(10 PLACES)



### **D3531-041 BRACKET ASSEMBLY**

#### **NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING  
WHITE MARKER ON INSIDE OF BRACKET  
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET  
THROUGH D3531-3 BRACKET FRONT PLATE  
BEFORE FINISHING

#### **PARTS LIST**

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

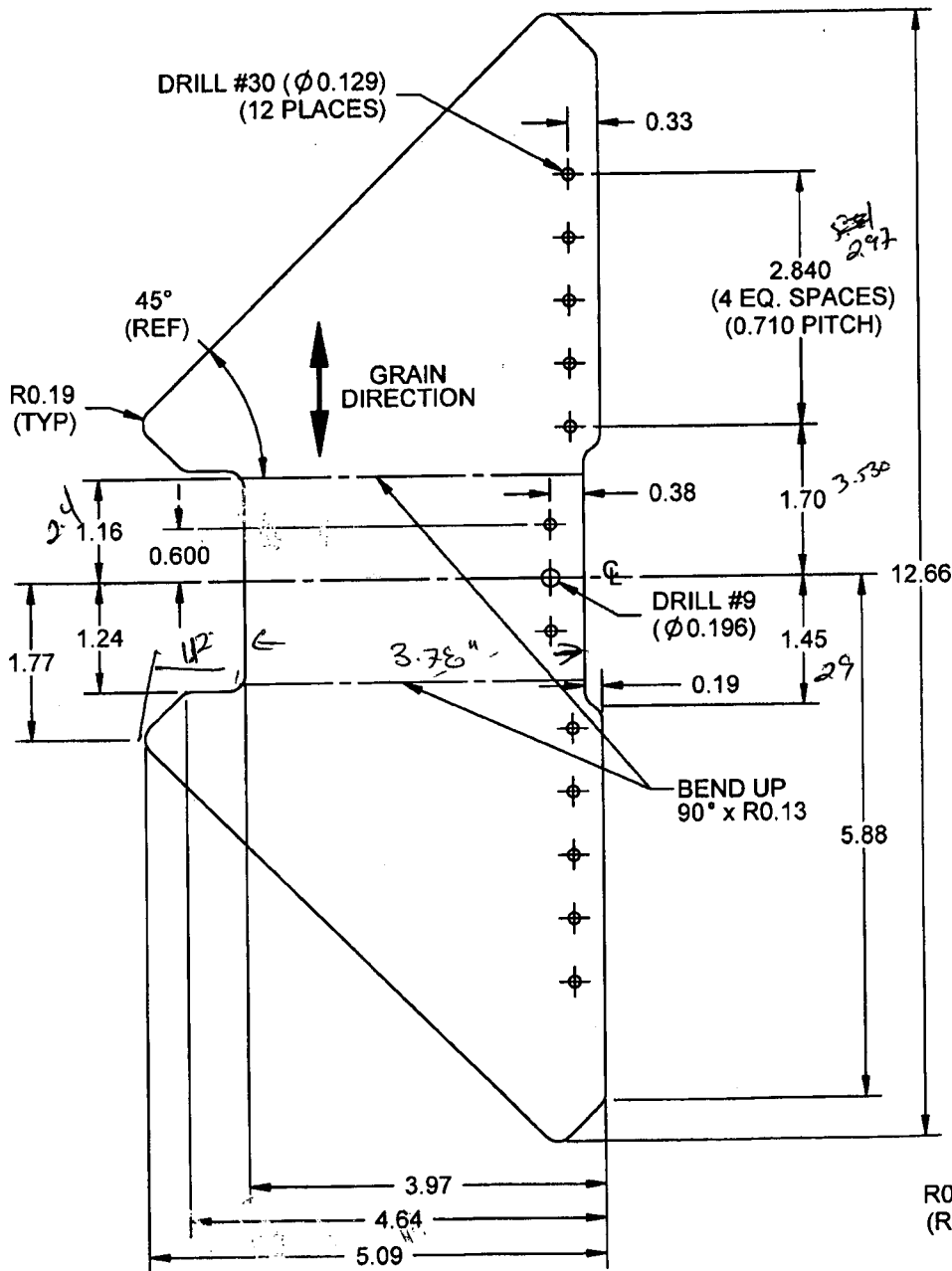
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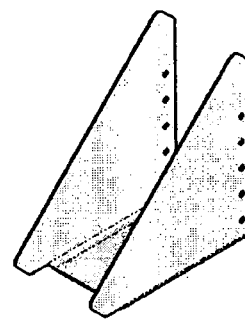
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WIT  
WIT  
NO. **DART**  
33023

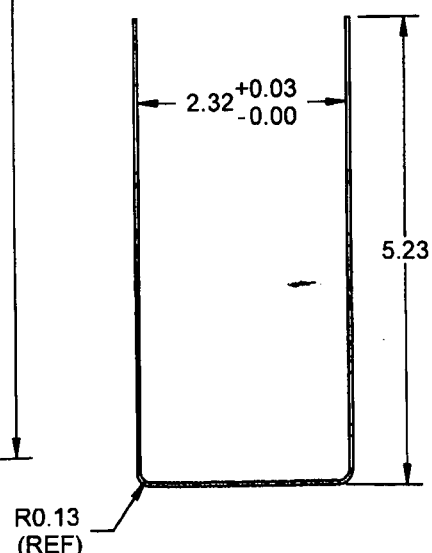
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED A	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2



**D3531-1F FLAT PATTERN**



**RELEASED**  
07.08.03



**D3531-1 BRACKET**

**NOTES:**

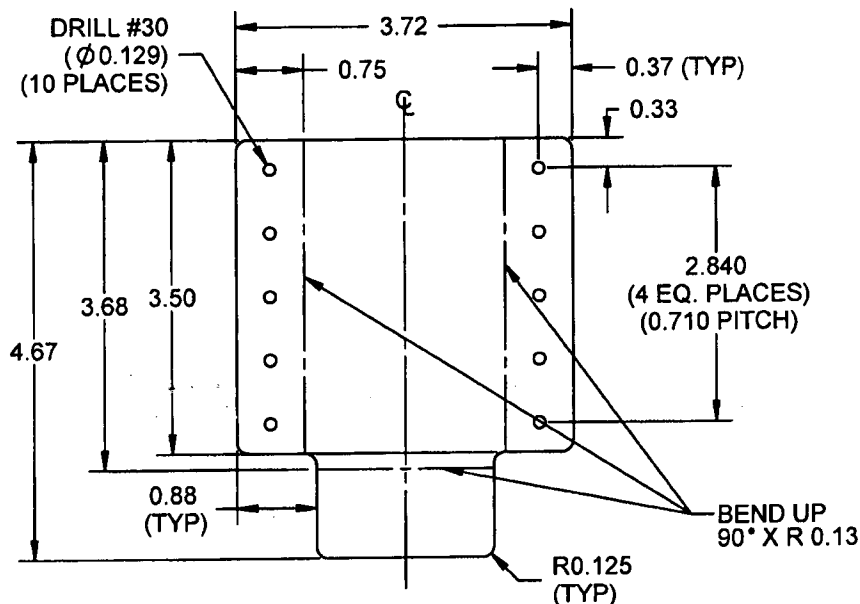
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

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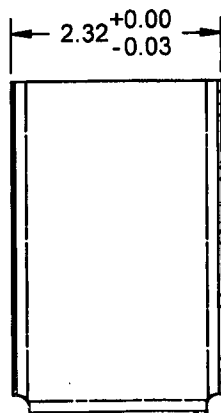
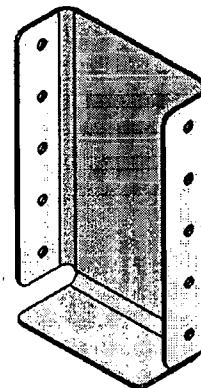


DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3531</b>	REV. A SHEET 3 OF 3
DATE <b>07.06.19</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:2

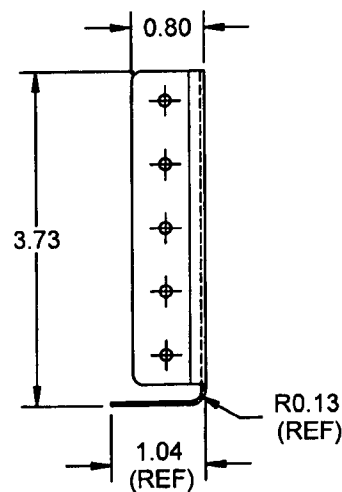


**D3531-3F FLAT PATTERN**

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07.08.03



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**D3531-3 BRACKET FRONT PLATE**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

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